

Work Order ID 80624

Friday, February 24, 2012 1:52:08 PM

80624

SOON

Item ID: D3955-23

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Template

Start Date: 2/24/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 2/28/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: *MF* Date: *12-02-24* Tooling:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Date:

Stop ***NR2***

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3955

A

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3955

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

12 02 26 (6)

12 02 26 (6)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: 077

0.00

130

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

5/26/27

(x6)

6/24/28 (6)

12/2/28
MF
12-02-28

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Picklist Print

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Work Order ID: 80624
Parent Item: D3955-23
Parent Item Name: Template

Start Date: 2/24/2012

Required Date: 2/28/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040 6061-T6 .040 Sheet		Purchased	No				sf	294.9670		2.5023158			

Location

Loc Qty

Loc Code

MAT021

294.967

117653

27.91

120154

90

120218

177.057

W 12 02 26

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DART AEROSPACE LTD		Work Order: 80624
Description: Template		Part Number: D3955-23
Inspection Dwg: D3955	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	0.100	✓		Vern	HB-02
Ø0.129	+0.005/-0.001	0.129	✓		Vern	" "
0.750	+/-0.010	0.749	✓		Vern	" "
1.000	+/-0.010	1.005	✓		Vern	" "
1.250	+/-0.010	1.248	✓		Vern	" "
1.375	+/-0.010	1.375	✓		Vern	" "
2.563	+/-0.010	2.568	✓		Vern	" "
0.800	+/-0.010	0.798	✓		Vern	" "
1.500	+/-0.010	1.500	✓		Vern	" "
2.250	+/-0.010	2.248	✓		Vern	" "
2.750	+/-0.010	2.755	✓		Vern	" "
3.250	+/-0.010	3.253	✓		Vern	" "
5.000	+/-0.010	5.003	✓		Vern	" "
6.500	+/-0.010	6.498	✓		Vern	" "
7.500	+/-0.010	7.505	✓		Vern	" "
8.000	+/-0.010	8.000	✓		W.T	W.T-02
8.500	+/-0.010	8.500	✓		W.T	" "
9.375	+/-0.010	9.375	✓		W.T	" "
9.625	+/-0.010	9.625	✓		W.T	" "
10.600	+/-0.010	10.600	✓		W.T	" "
11.13	+/-0.030	11.13	✓		W.T	" "
0.040	+/-0.010	0.039	✓		Vern	

Measured by: [Signature]	Audited by: [Signature]	Prototype Approval:	N/A
Date: 12/02/26	Date: 02/02/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ [Signature]	[Signature]

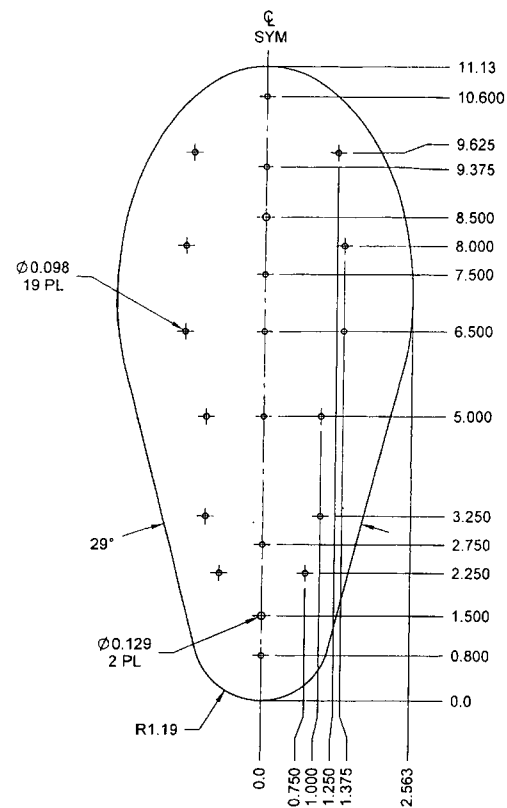
Dart Aerospace Ltd

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#80624

D3955-23 TEMPLATE

RELEASED
01/17/2010

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.040 THICK SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.040)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-23" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.16 lbs

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3955	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE TUNING KIT	NTS
DATE	09.07.21	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

Dart Aerospace Ltd

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